

Cast Metal Letters Specifications

Part I – General

1.1 Scope

A. Furnish letters and hardware necessary to install cast letters shown on drawings and herein specified.

1.2 Submittals

A. Manufacturer's illustrated product literature and specifications.

B. Installation instructions

1.2 Quality Assurance

A. Manufacturer to have a minimum of 20 years experience in manufacturing letters.

B. All letters to be manufactured by one manufacturer.

Part II – Products

2.1 Acceptable Manufacturer or Manufacturer's Representative

A. Gemini Incorporated

103 Mensing Way

Cannon Falls, MN 55009

Phone: 800-538-8377 or 507-263-3957

Fax: 800-421-1256 or 507-263-4887

Email: sales@signletters.com

Web: www.signletters.com

2.2 Materials (Metal Alloys)

A. Aluminum – 319 Alloy/514 Alloy

B. Bronze – NAVY G – no-lead bronze

2.3 Finishes

A. Aluminum

1. Natural Satin faces, bead-blasted returns, clear acrylic polyurethane powder-coated, baked.

2. Baked Enamel, bead-blasted returns, #319 aluminum alloy, baked.

3. Clear Anodized, bead-blasted returns, #514 Alloy.

4. Gold anodized, bead-blasted returns, #514 Alloy.

5. Medium bronze anodized, sanded return, #514 Alloy.

6. Dark bronze anodized, sanded return, #514 Alloy.

7. Black anodized, sanded return, #514 Alloy.

B. Bronze

1. Natural satin faces, bead-blasted returns, sprayed with 2-part hardened acrylic polyurethane clear coat, NAVY G 88-0-4 lead- and mercury-free bronze alloy, baked.

2. Polished, US9 Finish, hand-polished face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat, NAVY G 88-0-4 lead- and mercury-free bronze alloy, baked.

3. Oxidized, NAVY G 88-0-4 lead- and mercury-free bronze alloy, 2-part hardened acrylic polyurethane clear coat, US10B finish, baked.

4. Green Patina, varies from letter to letter, not uniform.

2.3 Mounting Hardware

A. Cast metal letters have threaded stud bosses or are drilled & tapped for stud insertion.

B. All aluminum letters under 18" use aluminum studs, type based on stroke and thickness.

C. All other letters use stainless steel studs.

2.4 Manufacture

A. Cast metal letters shall be made of _____.

B. Letter shall be _____ letter style and shall be _____ inches high, as indicated on the drawings.

C. Finish shall be _____.

D. Mounting shall be _____ and a mounting template designating stud locations is/is not required for mounting on a _____ surface

Part III – Execution

3.1 Installation

A. A qualified installer shall install cast letters.

3.2 Warranty

A. Letters should be guaranteed for the life of the business against defects.